

Date: Monday, 4/23/2007 1:52:35 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 31992		
Estimate Number	: 12731		
P.O. Number	: <u>N/A</u>	Part Number	: D353535
This Issue	: 4/23/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D3535 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision	: <u>KB</u> PH 07.04.30
Previous Run	: 30751	Material	: <u>N/A</u>
Written By	:	Due Date	: 4/30/2007 Qty: <u>26</u> Um: Each
Checked & Approved By	: <u>PH 07.04.26</u>		
Comment	: Est Rev: A New Issue 07-02-15 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.8423 sf(s)/Unit Total : 16.8462 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: M101823

SAD 07/04/30

26

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: B

Prog Rev: B

SAD 07/04/30

26

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/04/30

26

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SB 07.05.01

26

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Deburr if necessary

2-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.

3-Identify as D3535-35.

SB 07/05/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: P Date: 07/05/04

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:52:35 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 31992

Part Number: D353535

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/02 (26)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

07-05-03 (26)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/05/04 (26X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: EP-15

07/05/04 (26X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/04 (26)

Job Completion



07-05-04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

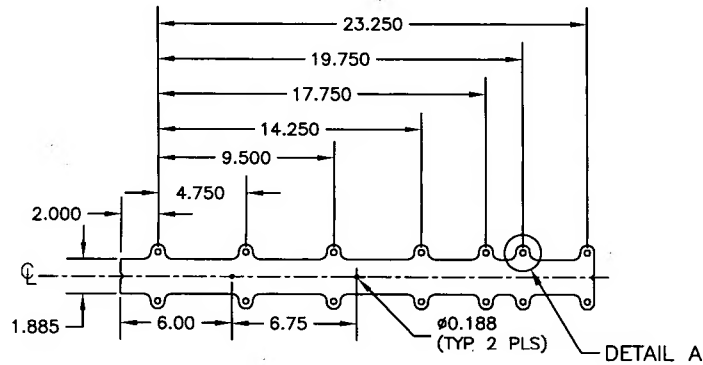
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

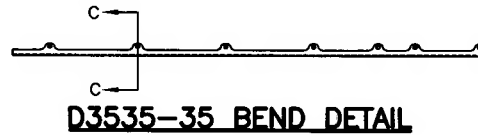
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

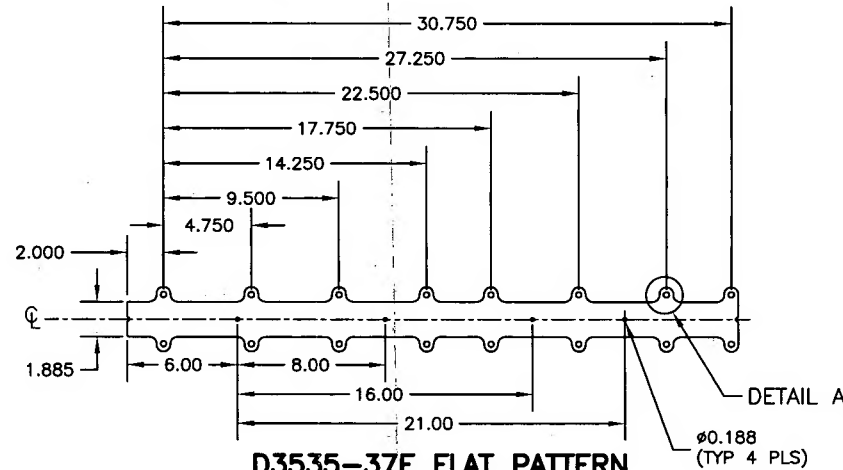
PRELIMINARY ISSUE



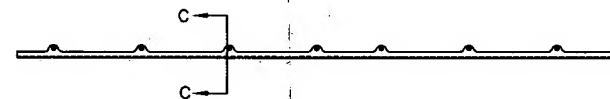
D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

NOTES

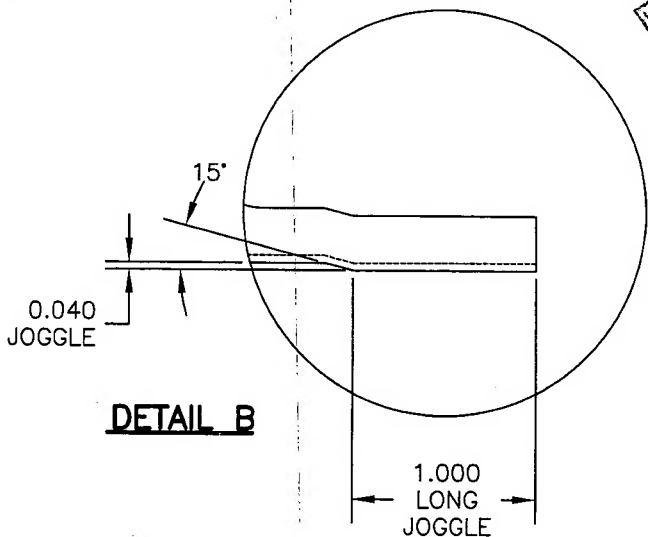
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

SHOP COPY
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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31492

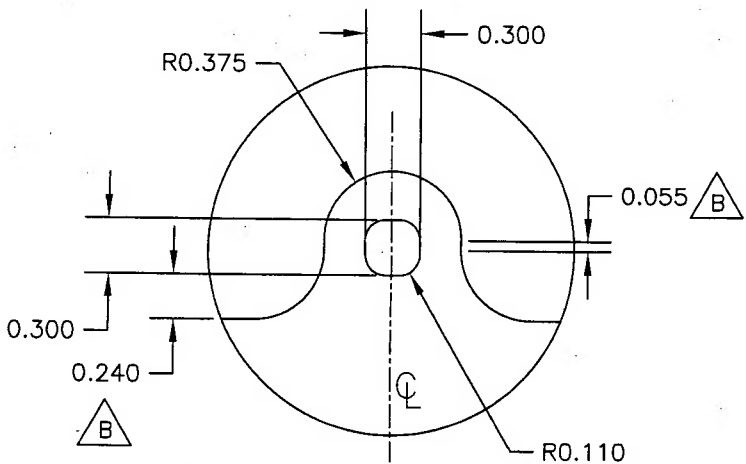
DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3535	REV. B
DATE 07.04.17	TITLE WEARSHOE	SHEET 5 OF 7	SCALE 1:10

PRELIMINARY ISSUE

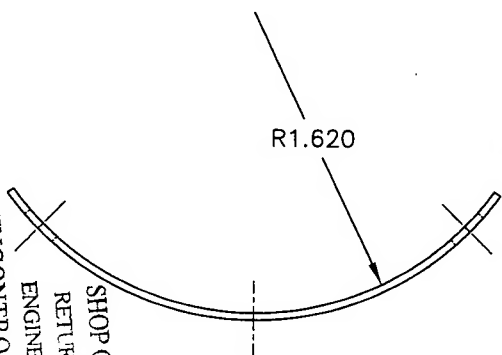
DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3535	REV. B
DATE 07.04.17		TITLE WEARSHOE	SHEET 7 OF 7
		SCALE 1:1	



DETAIL B



DETAIL A



SECTION C-C

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 31992

DART AEROSPACE LTD		Work Order: 31992
Description: WEAR PLATE		Part Number: D353535
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 2.000	+/- 0.010	2.007	✓		Vern	
B 1.885	+/- 0.010	1.887	✓		Vern	
C 6.00	+/- 0.030	6.01	✓		Vertical Vern	
D 6.75	+/- 0.030	6.754	✓		Vern	
E Ø0.188	+0.005 -0.001	Ø0.190	✓		Vern	
F 23.250	+/- 0.010	23.250	✓		M-T	
G 19.750	+/- 0.010	19.750	✓		M-T	
H 17.750	+/- 0.010	17.750	✓		M-T	
I 14.250	+/- 0.010	14.250	✓		M-T	
J 9.500	+/- 0.010	9.500	✓		Vern	
K 4.750	+/- 0.010	4.752	✓		Vern	
L Ø.360	+/- 0.010	Ø.296	✓		Vern	
M 0.300	+/- 0.010	0.296	✓		Vern	
N 0.038	+/- 0.010	0.036	✓		Vern	
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAD	Audited by: BG	Prototype Approval:	N/A
Date: 07/04/30	Date: 07-05-41	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	